TABLE I. DEVICE PARAMETERS 1/

JPL PART NO. ST12150-	MFR.	MFR. PART NO.	MIL PART NO. REF.	FUNCTION	RESISTIVE CONTACT RTG. PER POLE 2/	TERMINAL TYPE 2/	CIRCUIT DIAGRAM 2/	SCREENING REQUIREMENT 3/	DELTA LIMITS 3/	LOT QCI REQUIRE-MENTS 3/
K0KCL28LL	LEACH	KCL-A2A-024	MS27742-1 2/	3 PDT LATCHING	25A, 28V	SOLDER LUG	FIG. 1	TABLE XIX ¶4.6 & HEREIN	TABLE XIXa	N/A
K0KCL28PL	LEACH	KCL-A1A-017	MS27742-2 2/	3 PDT LATCHING	25A, 28V	PIN	FIG. 1	TABLE XIX ¶4.6 & HEREIN	TABLE XIXa	N/A
K0KCL28ML	LEACH	KCL-D2A-093	MS27742-1	3 PDT LATCHING	25A, 28V	SOLDER LUG	FIG. 1	TABLE XIX ¶4.6 & HEREIN	TABLE XIXa	N/A

NOTES: 1/ This drawing, in conjunction with CS515903 and MS27742(USAF), imposes all requirements for procurement of these relays.
2/ Refer to MS27742(USAF). Exception: there shall be no "L" mounting tabs.
3/ Refer to CS515903.
4. This standard takes precedence over documents referenced herein.

REQUIREMENTS:

1. In-process inspection shall be per CS515903 and the following:

1.1 Coils. A random sample of 20 coils shall be subjected to destructive inspection in accordance with Leach procedure [TBD].

1.2 Motor and moving contact assembly. JPL QA will witness Leach 100% inspection of the motor and moving contact assembly and/or perform an additional inspection (limited to 10X). In addition:

a. There shall be no blisters in the plating.

b. The armature shall rotate about its axis freely between two brackets on armature hinge-pins inserted in hinge-bracket holes. Each bracket shall not extend beyond its respective surface -A- or -B-, where surfaces -A- and -B- are parallel planes at opposite sides of the assembly.

c. Lateral armature movement shall be ≤0.010".

d. Hinge-pin to hinge-bracket-hole clearance shall be 0.001 ± 0.0005 inches.

RELEASED THRU SECTION 356 DATA MANAGEMENT:		DATE:	
REVISION: D APPROVED BY:		DATE:	
APPROVED SOURCE(S)			
VENDOR PART NO.	VENDOR	JPL PART NO.	ONLY THE ITEM LISTED IN THE APPROVED SOURCE BLOCK AND IDENTIFIED BY VENDOR NAME, ADDRESS,AND PART NUMBER HAS BEEN EVALUATED AND APPROVED BY THE JET PROPULSION LABORATORY OR ITS DELEGATED ALTERNATE. A SUBSTITUTE ITEM SHALL NOT BE USED WITHOUT PRIOR EVALUATION AND APPROVAL BY JPL OR ITS DELEGATED ALTERNATE.
KCL TYPE (SEE TABLE I)	LEACH CORPORATION BUENA PARK, CA 90622-5032 CAGE NO.: 58657	SEE TABLE I	

JET PROPULSION LABORATORY CALIFORNIA INSTITUTE OF TECHNOLOGY

Procurement specification: CS515903 Screening specification: ZPP-2073-GEN	TITLE: RELAY, ELECTROMAGNETIC, MAGNETIC LATCH, 25 AMPS, 3PDT, HERMETIC	JPL CAGE NO.:23835 **ST 1215Ø**
Custodian: Electronic Parts Reliability Section 514		SHEET 1 OF 2

FILE: (Sec.514): F:\USERS\514\SPECS\ACT-DETL\ST12150.D

REQUIREMENTS (CONTINUED):

1. Continued,

1.2 Motor and moving contact assembly, continued

e. Motor and moving contact assembly shall be in accordance with Leach

2. Preseal inspection shall be in accordance with CS515903 and the following:

2.1 JPL QA source inspection. JPL QA will perform 100% visual inspection at preseal (limited to 20X) and will witness 100% small particle inspection.

2.2 Small particle inspection. Small particle inspection shall be in accordance with Leach procedure 400-0366-000.

3. Terminal material shall be Carpenter alloy 42-6 or 44-6.

4. Terminal and header finish shall be solder plate per Leach system 001-1894-016.

5. Arc barriers shall not be included in the relays.

6. Enclosure (can) finish shall be paint per Leach system 300-0017-017.